



[TRANSLATION]

SELF-SEALING COMPACT SPINNERET FOR THE MELT SPINNING PROCESS

(DESCRIPTION:)

*CROSS REFERENCE TO SPECIFICATION
SPECIFICATION
CROSS REFERENCE TO RELATED APPLICATIONS
This application is a national stage of PCT/EP00/05840 filed 24 June 2000 and is
based upon German national application 199 35 982.2 filed 30 July 1999
under the International Convention*

FIELD OF THE INVENTION

5 The invention relates to a spinneret for the spinning of
thermoplastics having a central polymer melt inlet passage, a
filter arrangement comprised of one or more filter disks of
different filter finenesses ~~or~~ filter grades, a spinneret plate and
a housing close-fitting around and receiving the filter arrangement
and the spinneret plate.

BACKGROUND OF THE INVENTION

10 Pressure build-up, shear and filtering of the polymer to
be spun in a spinneret are usually accomplished by means of a sand
filling as is described for example in U.S. Patent 5,304,052 or
U.S. Patent 5,795,595. These sand fillings, whether of steel grit
or pure quartz sand, are however associated with various drawbacks:
15 for one, the sand fillings themselves are not identical from
spinneret to spinneret even when prepared with the greatest of care
and for another there are handling difficulties with respect to
filling with sand and the transport of the filled spinnerets.
Apart from this, discrete sand grains can render the internal seals
20 of the spinnerets ineffective. These seals formed during the
incorporation of the sieve filter, form first of all overflows

because of their U shape and also small dead zones, i.e. in the U shaped configurations, exchange is rendered difficult and can result in a decomposition of the polymer. There is also a cost factor. Each component contributes to cost and seals are the origin of ongoing operating costs since they can be used only once and with each nozzle replacement must be renewed. In addition they can provide no absolutely reliable seal as is known in practice since fabrication and mounting defects invariably increase with increasing numbers of the individual parts.

To alleviate some of the drawbacks associated with sand fillings it has been proposed to provide a filter construction as is known for example from DE 29 26 533 C2. Thus a method has been provided in which the individual filter disks are cold-pressed together so that a substantially better filter effect is produced than is the case with an ^{otherwise} identical arrangement with loose filter disks. Such cold-sintered filters are provided with a sealing enclosure and are supplied by various suppliers under commercial names like "Porostar" or Multipor". The sealing enclosure can suppress the aforementioned drawbacks.

OBJECT OF THE INVENTION
The object of the present invention is to provide a spinneret for the spinning of thermoplastics which avoids the aforementioned drawbacks both from the point of view of sand fillings as well as the sealing enclosures. As a result the spinneret should have a configuration that is as compact as possible. {The solution to these objects is achieved according to

the invention with a spinneret according to the features of the patent claims.] *SUMMARY OF THE INVENTION*
INSERT "A" *therefore,*

According to the invention, ~~filter~~ structures of filter disks cold-pressed against one another are used but without the conventional sealing housing by providing them in a housing bore which matches them as precisely as is possible, *i.e. a* ~~press fit~~, whereby the material of the filters should have a substantially higher coefficient of thermal expansion than the material of the housing. The sealing of the filter structure is effected at the operating temperature by thermal expansion and with the spinneret plate in an optional manner.

Further it is proposed to fabricate the spinneret plate out of a material with a high coefficient of thermal expansion and to insert it into a bore in the housing which receives it in as close to a matching fit, *i.e. a* ~~press fit~~, as is possible. In this case the sealing of the spinneret plate is effected at the operating temperature by thermal expansion. The filter arrangement can be constructed in an optional manner and can be fabricated from a material with an optional coefficient of thermal expansion.

Preferably the filters of the filter disks cold-pressed together as well as the spinneret plates are composed of materials of high coefficients of thermal expansion and both parts are inserted in bores with press fits in a housing fabricated from a material with a lesser coefficient of thermal expansion.

Preferably the spinneret plate is additionally provided with a thread in its lower half and directly screwed into the

housing so as to obtain the tight fit sealing seat described previously, the thread and the abutment of the spinneret in the housing being so formed that the spinning hole pattern is always in
5 [the spinning hole pattern is always in] the same orientation. This ensures that by screwing it in to its abutment ~~for stop~~, the correct blowing onto the filaments as they are spun out is effected.

10 Preferably the housing at its lower end is provided with a projecting collar which has at least three grooves for receiving a tool for screwing the spinning system in or out and which protects the spinneret against detrimental contact during the handling.

15 The filter unit according to the invention avoids the drawbacks of classical sand filtration. The elimination of the conventional sealing results in a significant cost saving and enhanced sealing reliability. By the suitable choice of materials and tolerance of fit of the individual parts of the spinneret according to the invention, the sealing effect is brought about at the operating temperature by the increased expansion of the inner
20 components, namely the filter and/or the spinneret plate, with respect to the outer lying housing, without the requirement for additional elements. Further the short and compact construction is advantageous: cost effective fabrication and easier handling with more uniform and identical filtration from nozzle to nozzle.

25 The detailed description of a preferred embodiment of the invention follows in connection with FIG. 1 which (shows) *is a cross sectional view of*

Illustration of a spinneret arrangement according to the invention,
by way of example: In a housing 1, a cold-sintered filter 2 is
disposed, ^{of this filter 2} whose construction comprises individual layers of filter
disks of different filter fineness, specifically selected for the
particular spinning process, on a spinneret plate 3. In this
exemplary spinneret arrangement, the spinneret plate 3 is fastened
by means of a thread in the housing 1. ^{The} This thread in the housing
1 and on the spinneret plate 3 are ^{thus} so configured that upon
screwing of the plate in until it reaches an abutment ^{or} stop the
spinning orifice pattern is always located at the same place so
that the correct blowing onto the filaments as they are spun out of
the orifices can be assured. The connection of the polymer melt
supply is effected via the connecting seal 4 and adapter (not here
further shown) to the heating vessel (also called the spinning
beam). The embodiment can be matched completely to the
requirements of the user and the equipment available to him.

The housing 1 is comprised of material No. 1.4057
(according to German Industrial Standard - Steel Key), a material
with a relatively low thermal expansion coefficient. The spinneret
plate 3 can be composed of material No. 1.4580 and the filter
structure 2 of material No. 1.4301 or 1.4541, all materials with a
relatively high coefficient of thermal expansion. The fits are so
selected with respect to the dimensions and materials that the
individual parts, in a cold state can easily be fitted together and
disassembled from one another and that the sealing effect on the
one hand will result at the latest shortly before the specific

spinning temperature is reached and on the other hand the parts at elevated cleaning temperature (about 450 - 540°C) will not be damaged by overexpansion.

5 The desired self-sealing function in the operating state is achieved without conventional seals by the targeted pairing of materials and selection of the fits: the four parts, housing 1, filter 2, spinneret plate 3 and connection seal 4 are mounted together in the cold state and thereafter heated as is customary. Because of the different thermal expansions, the sealing effect
10 arises and the spinneret can spin the filaments at optional pressure. The outer housing 1 is thus comprised of material of a relatively low coefficient of thermal expansion and the inner parts, filter 2 and/or spinneret plate 3 can be fabricated by contrast of a material with a higher thermal expansion coefficient.
15 The dimensions are so selected that the parts can easily be mounted in the cold state (room temperature) but at the operating temperature for spinning (about 300°C) because of the differential expansion can yield a self-sealing press fit between the parts. Upon termination of spinning, the complete spinneret is subjected
20 to a cleaning and first after cooling is disassembled. Thereafter, the spinneret plate 3 and the filter element 2 which can thus be used primarily like a filter candle, can be further cleaned and scraped or subjected to ultrasound.

25 The sealing principle here expounded upon using differential thermal expansion is not limited to the described spinnerets and filter uses but can be used universally wherever

filtering, shearing or spinning is desired whether for microfibers, textile filaments, high strength tire cords or other applications. It remains for the product or applications expert to select the configuration by the choice of the cold-sintered filter, the materials and the fits for their special cases either by analysis or empirically.

Reference character list:

1. Housing
2. Filter structure, filter
- 10 3. Spinneret plate, nozzle plate
4. Connection seal

~~Patent Claims:~~

INSERT "A"

According to the invention a)

1. A spinneret for spinning thermoplastics ^{has} with a central polymer melt inlet passage, a filter arrangement (2) comprised of a plurality of filter disks of different filter fineness which are fixedly bonded together by cold pressing, a spinneret plate (3) and a housing (1) which closely surrounds and receives the filter arrangement (2) and the spinneret plate (3), ~~characterized in that~~ ^{The} said filter arrangement (2) has no sealing enclosure and is comprised of a material with a higher thermal expansion coefficient than that of the material from which the housing (1) surrounding it is fabricated.

~~2. A spinneret for spinning of thermoplastics having a central polymer melt inlet passage, a filter arrangement (2) comprised of one or more filter disks of different filter fineness and optional type, a spinneret plate (3) and a housing (1) surrounding and receiving the filter arrangement (2) and the spinneret plate (3) characterized in that~~ ^{can be} ~~The spinneret plate (3)~~ is comprised of a material with a higher thermal expansion coefficient than that of the material from which the housing (1) surrounding it is fabricated.

~~3. A spinneret for spinning of thermoplastics having a central polymer inlet passage, a filter arrangement (2) comprised of~~

~~a plurality of filter disks of different filter fineness which are~~
 fixedly bonded together by cold pressing with one another, and a
 spinneret plate (3) and a housing (1) closely surrounding and
 receiving the filter arrangement (2) and the spinneret plate,
~~characterized in that the said filter arrangement (2) has no~~ *can have*
 sealing enclosure and the filter arrangement (2) and the spinneret
~~plate (3) are~~ *can both be* comprised of materials with a higher thermal
 expansion coefficient than the material from which the housing (1)
 surrounding them is fabricated.

~~4. The spinneret according to (one of claims 1 to 3)~~ *claim 1*
~~characterized in that the spinneret plate (3) and/or the filter~~
~~arrangement (2) are~~ *can be* composed of austenitic steel like for example
 Nos. 1.4301, 1.4541, 1.4580 or a material with a similarly high
 thermal expansion coefficient and ~~that the housing (1) surrounding~~
~~them is~~ *can be* fabricated from a material with a lower coefficient of
 thermal expansion like, for example No. 1.4057 or a similar
 chromium steel or refractory material.

~~5. The spinneret according to (one of claims 1 to 4)~~ *claim 1*
~~characterized in that the dimensioning is~~ *can be* so selected that the fit
 between the outer diameter of the spinneret plate (3) and/or the
 filter arrangement (2) on the one hand and the bore receiving it in
 the surrounding housing (1) on the other hand provides a slight
 play fit at room temperature which is transformed at operating

temperatures based upon the different expansions of the parts, into a self-sealing radial press fit.

claim 2
~~6. The spinneret according to one of claims 2 to 5~~
characterized in that *can be* The spinneret plate (3) ~~is~~ comprised of a material with a higher thermal expansion coefficient than the material of the housing (1) surrounding it and ~~that~~ the spinneret plate (3) *can have* ~~has~~ in its lower half additionally a thread ~~provided~~ which is directly screwed into the housing (1) whereby the thread and the stop of the spinneret plate (3) in the housing (1) are so formed that the spinning orifice pattern always has the same orientation so that the correct blast on the filaments as they are spun is ensured by the screwing of the spinneret plate (3) to its stop.

claim 1
~~7. The spinneret according to one of claims 1 to 6~~
characterized in that *can have* The housing (1) ~~has~~ at its lower end a projecting collar which has at least three grooves for receiving a tool for screwing the spinning system in and out, ~~and in that~~ The spinneret plate (3) *can be* ~~is~~ thereby protected against detrimental contact during handling.